

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:** Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-013520**Date Inspected:** 30-Mar-2010**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1900**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** You Qi Guo**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** Tower Components**Summary of Items Observed:**

On this date Caltrans Office of Structural Materials Quality Assurance Inspector, Sandeep Kumar (QA) was present during the times noted above for observations relative to the work being performed.

Tower Trial Assembly

This QA Inspector observed the following work in progress:

This QA Inspector carried out the measurements on Tower Strut Plate to Tower Diaphragm gap at top and bottom sides. The measurements were taken at 23Metre, 28Metre, 33Metre and 38Metre elevations of erected tower lift-1 . Measurements were recorded on the data sheet and submitted to the assigned task leader. The members are identified as Tower Components. The members designation reviewed are as follows:-

23 Metre Elevation

1. ND1-A468-23M-1
2. ND1-A468-23M-2

28 Metre Elevation

1. ND1-A468-28M-1
2. ND1-A468-28M-2

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33 Metre Elevation

1. ND1-A468-33M-1
2. ND1-A468-33M-2

38 Metre Elevation

1. ND1-A468-38M-1
2. ND1-A468-38M-2

Flux Core Arc Welding (FCAW):

Weld joint # 062 located on North Tower Lift-1 Bearing stiffener Plate NSD1 – SA17F/G. Welder is identified as 037907. ZPMC Quality Control (QC) Inspector is identified as You Qi Guo. The welding variables recorded by QC appeared to comply with the WPS – B – T – 2333 – Tc – P4 – F.
(See attached photo)

Weld joint # 019 located on North Tower Lift-1 Bearing stiffener Plate NSD1 – SA22B/E. Welder is identified as 057180. ZPMC Quality Control (QC) Inspector is identified as You Qi Guo. The welding variables recorded by QC appeared to comply with the WPS – B – T – 2333 – Tc – P4 – F.

Weld joint # 002 located on West Tower Lift-1 Shear Plate at B/C corner outside WSD1 – A423A/H. Welder is identified as 059525. ZPMC Quality Control (QC) Inspector is identified as Zhu Yuan Yuan. The welding variables recorded by QC appeared to comply with the WPS – B – T – 2333 – Tc – P4 – F.

Weld joint # 001 located on South Tower Lift-1 Shear Plate at B/C corner outside SSD1 – A111A/H. Welder is identified as 054459. ZPMC Quality Control (QC) Inspector is identified as Zhu Yuan Yuan. The welding variables recorded by QC appeared to comply with the WPS – B – T – 2333 – Tc – P4 – F.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.



Summary of Conversations:

No Relevant Conversations.

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Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Skyler Guest - 15000422360, who represents the Office of Structural Materials for your project.

Inspected By:	Kumar,Sandeep	Quality Assurance Inspector
Reviewed By:	Clifford,William	QA Reviewer
